

Date: Tuesday, 12/20/2005 9:48:40 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 206L BASKET BASE
<b>Job Number</b>	: 23136A		
<b>Estimate Number</b>	: 11273		
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: D2252041
<b>This Issue</b>	: 12/20/2005	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: UNDER REVIEW
<b>First Issue</b>	: N/A	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: N/A	<b>Drawing Revision</b>	: E
	<b>Type</b> : LARGE FAB ASSY	<b>Material</b>	: N/A
<b>Written By</b>	: SEE COMMENT BELOW	<b>Due Date</b>	: 1/30/2006
<b>Checked &amp; Approved By</b>	: SEE COMMENT BELOW	<b>Qty:</b>	1
<b>Comment</b>	: Est Rev:l Revised as per Rev E 05-12-06 JLM	<b>Um:</b>	Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D31661	Basket Hoop
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**Comment:** Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)  
 Pick:

Qty	Part#	Description	Batch
5	D3166-1	Hoop	B24880

06/01/17

2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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**Comment:** Qty.: 25.0000 f(s)/Unit Total: 25.0000 f(s)  
 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: M19447

06/01/17

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1  
 1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.  
 Cut 5 D2235-1 From D3166-1

2- Cut Ribs as per Dwg D2252

3-Drill hole in D2252-1as per Dwg D2252

4-Deburr & Remove all Markings from Material

06/01/20

4.0	D22531	Lug
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
 Pick:

Qty	Part Number	Description	Batch
2	D2253	Gusset	B12413

06/01/20

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L BASKET BASE

Job Number: 23136A

Part Number: D2252041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D23273	Spacer Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D2327-3	Bushing	B24530
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06/01/20

6.0	D2581	Mounting Bracket
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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4	D2581	Mounting Chancel	B25139
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06/01/20

7.0	D2254	Gusset for D206bskt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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2	D2254	Lug	B23421
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06/01/20

8.0	D22323	Basket Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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2	D2232-3	HINGE	B24527
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06/01/20

9.0	D22531	Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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2	D2353-1	LUG	B12413
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06/01/20

10.0	M304EX07516F	Expanded Metal Flat Stai
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Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty	Part Number	Description	Batch
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32 sf	M304EX0.75-16F	Expanded Metal	M19149
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06/01/20

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #:

Machine Or Operation:

Description :

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig Debur as required

A/R SS ROD Batch: MA174

*06/01/20*

12.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

*PD 060120*

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*06 01 22*

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*060122*

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

*06-01-22*

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*595 06/01/23 (1) 06/01/23*

Job Completion



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/23

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries